

Work Order ID 54841

December 29, 2009 8:26:44 AM

Page 1

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Maintenance Step

Start Date: 12/30/2009 Start Qty: 4.00

Required Date: 1/13/2010 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *09-12-29* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2946

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-133 CHG003

*S 10/01/10**for BG 10/01/14*

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2622-120 extrusion to 62.06" long as per Dwg D2946

2-Deburr

****Ensure that 57.09" minimum extrusion is kept and identify to be used for D350-591-215/-216.*****10.01.11**4*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54841

December 29, 2009 8:26:44 AM

Page 2

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Maintenance Step

Start Date: 12/30/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

278 10/01/11

QC

Memo

0.00

(4)

Quality Control

130

Large Fab

0.00

Large Fab

Memo

0.00

1-Deburr and Bevel ends for welding

2-Weld (1) End Cap and (2) Lugs using Jig DT8440 as per Dwg D2946

A/RAluminum Rod m111 311
m111 494

3-Grind End Cap welds flush

10.01.11

4 φ

140

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

4

2E 10/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54841

December 29, 2009 8:26:44 AM

Page 3

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Maintenance Step

Start Date: 12/30/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

> 10/01/10



QC

Memo

0.00

(4X)

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00

10.01.18



HandFinish

Memo

0.00

4

Hand Finishing

170

QC3- Inspect Part Finish

0.00

m-d 10/01/10



QC

Memo

0.00

(4X)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54841

December 29, 2009 8:26:44 AM

Page 4

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Maintenance Step

Start Date: 12/30/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Remove alodine prior to welding. Weld end cap as per Dwg D2946. Grind end cap weld flush.

A/R AL ROD BATCH: M111311*10-01-20**4 0*

190

0.00



QC

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

Quality Control

PD 10.01.20

200

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*=> 510101/20**xy*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54841

December 29, 2009 8:26:44 AM

Page 5

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Maintenance Step

Start Date: 12/30/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Chemical Conversion Coat per QSI005 4.1

0.00

⇒ M 10-01-21

(X4)

φ

HandFinish

Memo

0.00

Hand Finishing

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M113170

⇒ M 10-01-21

(X4)

φ

Powdercoat

Memo

0.00

Powder Coating

START TIME: 2:30pm
OVEN TEMPERATURE: 320°C
FINISH TIME: 3:00pm

230

Wing Walk as per dwg QSI005 4.4 Batch 112900

0.00

BR 10-01-25

(4)

φ

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54841

December 29, 2009 8:26:44 AM



Page 6

Item ID: D350-591-133

Accept



Setup Start



Revision ID:

Item Name: Aft Maintenance Step

Stop



Start Date: 12/30/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240



QC

Quality Control

QC3- Inspect Part Finish

0.00

⇒ 81016126

Memo

0.00

(24)

250



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-1-26 (42) SP

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

⇒ 81016126

Memo

0.00

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 54841

December 29, 2009 8:26:44 AM

Page 7

Item ID: D350-591-133

Accept

Setup Start

Revision ID:

Item Name: Aft Maintenance Step

Stop

Start Date: 12/30/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 1/13/2010 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00



Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-591-133

Location: 61

PPP Rev: D

10-1-28

(4x2)

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/01/27

W 01.27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:43 AM

Page 1

Work Order ID: 54841

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step


Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			110	Each	85.8200	2.0800			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

85.82

48612

3.12

~~52026~~

82.7

Manufactured No

130

Each

27.0000

8.0000

D2734



Step End Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

27

43535

2

~~48110~~

25

Manufactured No

130

Each

41.0000

8.0000

D2944



Step Mounting Plate

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41

29351

3

~~53725~~

38

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:43 AM

Page 2

Work Order ID: 54841

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-11A		Purchased	No			250	Each	476.0000	16.0000			
---------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--

Bolt

Warehouse
Location

Main Warehouse

ST

110382

Loc Qty

476

476

Loc Code

250

Each

471.0000

32.0000

10-1-26 SP

Bolt

Warehouse
Location

Main Warehouse

ST

113359

Loc Qty

471

471

Loc Code

250

Each

134.0000

32.0000

10-1-26 SP

Bolt

Warehouse
Location

Main Warehouse

ST

112969

18949

Loc Qty

134

132

2

Loc Code

10-1-26 SP

32

December 29, 2009 8:26:43 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:43 AM

Work Order ID: 54841

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-7A

Purchased

No

250

Each

317.0000

8.0000



Bolt

10-1-26 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

317

112794

1

113226

316

AN960JD416

Purchased

No

250

Each

1,489.000

56.0000



Washer

1113288 10-1-26 sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1489

103691

20

104215

6

108161

329

110523

340

111279

101

111916

482

112314

211

16941

0

NA5114900463 2

PS1 017
54

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:43 AM

Work Order ID: 54841



Parent Item: D350-591-133



Parent Item Name: Aft Maintenance Step

Start Date: 12/30/2009

Required Date: 1/13/2010

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2230-1		Manufactured	No			250	Each	108.0000	16.0000			
---------	--	--------------	----	--	--	-----	------	----------	---------	--	--	--



10-1-26

SP

Lug

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

FG

104

53782

104

16

Main Warehouse

ST

4

51761

4

D2230-3



Manufactured No

250

Each

221.0000

16.0000



10-1-26

SP (4)

Lug

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST

7

50306

5

51568

2

Main Warehouse

ST176

100

53881

100

Main Warehouse

ST476

114

53781

114

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 5

December 29, 2009 8:26:43 AM

Work Order ID: 54841

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2732-030		Manufactured	No			250	Each	0.0000	32.0000			
-----------	--	--------------	----	--	--	-----	------	--------	---------	--	--	--



Rubber Cushion

(8X) 3.00" per DSI 9459 revB

MEASRP 10/11/26

D2856-400		Manufactured	No			250	f	298.7021	5.0400			
-----------	--	--------------	----	--	--	-----	---	----------	--------	--	--	--



Abraison Strip

B43113 10-1-26 \$

10-1-26 \$

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST403

298.7020842

50593

141.312084

52563

157.39

(2X) 4.00" X 7.20" per dwg

MEASRP 8/10/26

D2945		Manufactured	No			250	Each	4.0000	4.0000			
-------	--	--------------	----	--	--	-----	------	--------	--------	--	--	--



Step Mounting Plate

10-1-26

(40) \$

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

51680

4

y

December 29, 2009 8:26:43 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 29, 2009 8:26:43 AM

Work Order ID: 54841

Parent Item: D350-591-133

Parent Item Name: Aft Maintenance Step

Comments:

Start Date: 12/30/2009

Required Date: 1/13/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L4		Purchased	No			250	Each	4,325.000	56.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	---------	--	--	--



Nut



6
M108145 10-1-26 SF
4/2

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4325

102552

6

104248

6

110507

184

111827

3129

113422

1000

15924

0

SSx

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

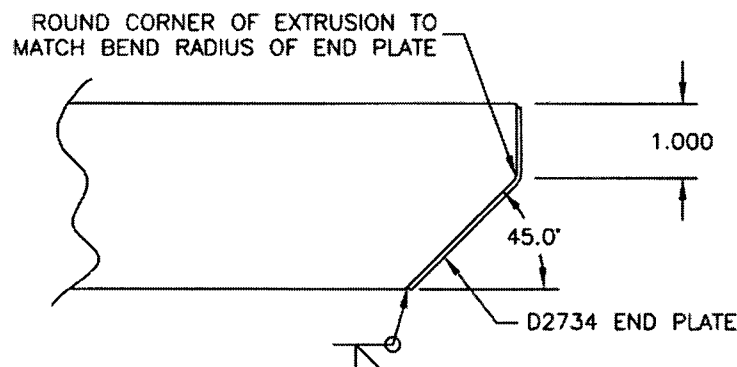
DART

D2946 STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2946	Step Assembly	X
D2622-63	STEP EXTRUSION*	1
D2734	END PLATE	2
D2944	STEP MOUNTING PLATE	2

*cut per drawing

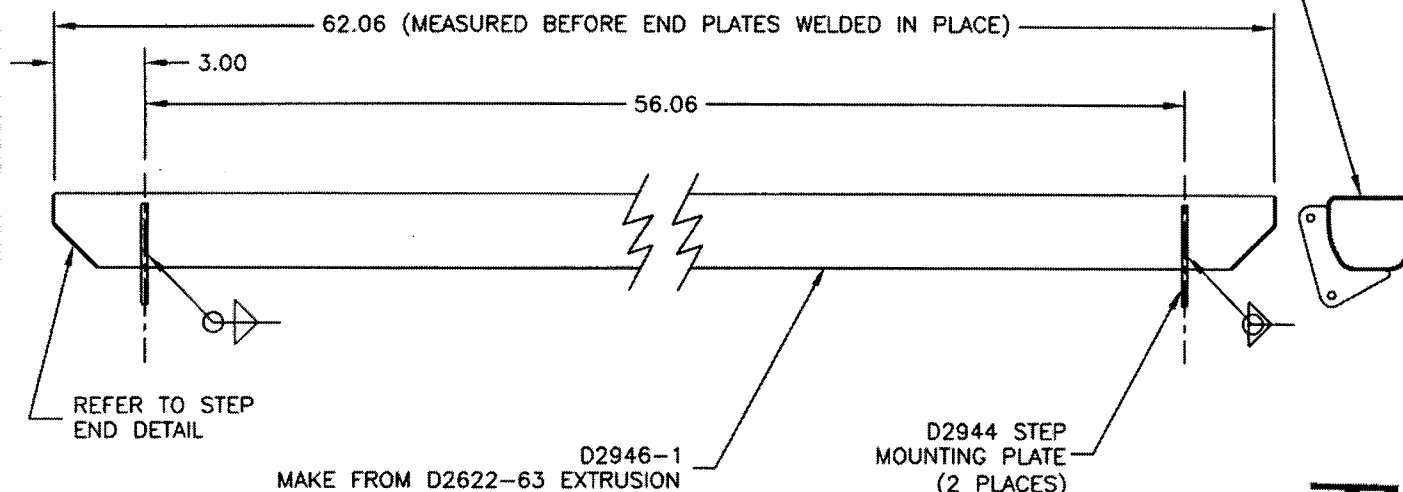
NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



TYPICAL STEP END DETAIL
NOT TO SCALE

#54841

APPLY BLACK ANTI-SKID ON TOP SURFACE TO BOTTOM OF TOP RADIUS



D2946-041 STEP ASSEMBLY

D2946 STEP ASSEMBLY

- 1) MAKE FROM D2622 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE LTD HAMMERSBURT, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2946
DATE	05.11.14			TITLE STEP ASSEMBLY
	A	99.12.13	NEW ISSUE	REV. B
	B	05.11.14	UPDATE FINISHING NOTE	SHEET 1 OF 1
				SCALE 1:6

RELEASED
05.11.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5. PARTS LIST

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<i>Heli-Access-Step</i> ™, Long Step – High Skid
	X					D350-591-113	<i>Heli-Access-Step</i> ™, Short Step – High Skid
		X				D350-591-115	<i>Heli-Access-Step</i> ™, Short Step – Low Skid
			X			D350-591-117A	<i>Heli-Access-Step</i> ™, Pre-Flight Step
				X		D350-591-119	<i>Heli-Access-Step</i> ™, Long Step – Low Skid
					X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
-2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER
REF CANADIAN STC: SH92-6
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying cross-tube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	Heli-Access-Step™, Short Step – High Skid, LH
	X				D350-591-122	Heli-Access-Step™, Short Step – High Skid, RH
		X			D350-591-123	Heli-Access-Step™, Short Step – Low Skid, LH
			X		D350-591-124	Heli-Access-Step™, Short Step – Low Skid, RH
				X	D350-591-133	Heli-Access-Step™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>92</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. REV. B DSI 9459 SHEET 1 OF 2 TITLE SCALE OPTIONAL CLAMP MODIFICATIONS NTS COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	<i>92</i>		
CHECKED	<i>PL</i>		
MFG. APPR.	<i>N/A</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	09.06.24		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries